

Date: Thursday, 2/14/2008 11:01:36 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 37444		Part Number	: D2884		
Estimate Number	: 11055		Drawing Number	: D2884 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 2/14/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	: 35497		Due Date	: 3/15/2008	Qty:	60
Written By	:		Um:	Each		
Checked & Approved By	:					
Comment	: Est A 99.10.12 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM Est Rev:C Now on Waterjet 06-08-23 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.0663 sf(s)/Unit Total : 3.9753 sf(s) Material: 6061-T6 0.080" Thick Batch <u>106330</u> <u>RB</u> <u>8-2-20</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2884 Dwg Rev: <u>B</u> <u>RB</u> <u>8-2-20</u> Prog Rev: <u>B</u> <u>RB</u> <u>8-2-20</u> 2-Tumble ,Deburr if necessary <u>H</u> <u>08/02/21</u> <u>88</u> <u>88</u> <u>km</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>RB</u> <u>8-2-20</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>Jos 02.22</u> <u>88</u> <u>counted</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<u>88X</u> Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>M-f</u> <u>08/02/25</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD

08/02/25

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 52

8/2/25

50

88X

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/26

Job Completion



2008 8/2/25

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37444
Description: Saddle Spacer	Part Number:	D2884
Inspection Dwg: D2884	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

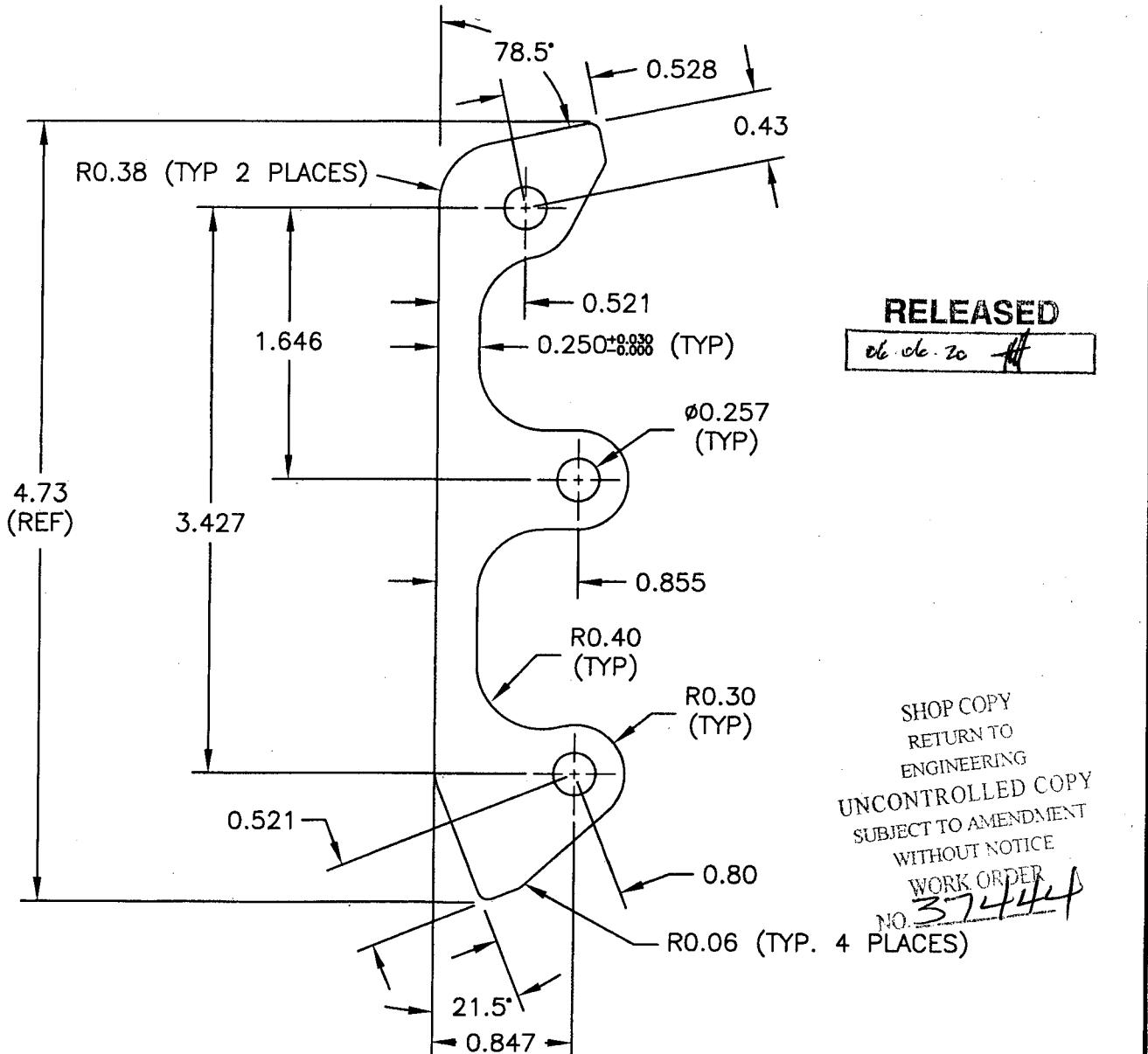
X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: 8-2-20	Date: 08-02-20	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.12.07	New Issue	KJ/JLM	E

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2884
PH		REV. B SHEET 1 OF 1
DATE		TITLE SADDLE SPACER
06.05.29		SCALE 1:1
A	99.04.01	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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